D3139-1
B 110721

Ship Wed- 23rd July

# Work Order ID 110721

*January-07-14 3:01:34 PM*

*110721*



**Item ID:** D3139-1 **Accept**

**Revision ID:**

**Item Name:** Guard

**Start Date:** 1/07/14 **Start Qty:** 4.00 10 MT *4*

**Required Date:** 1/07/14 **Req'd Qty:** 4.00 *4*

**Reference:**

*N900040100* **Setup Start** *NS1*

**Stop** *NS2*

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** MP MCJ **Date:** 14/01/08 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | FLOW WATER JET | 0.00 | | | | 12 | | EC 14-7-14 | |
| *100* | | 0.00 | | | | | | | |
| Waterjet | **Memo** | | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg<br>Dwg Rev: C<br>Prog Rev: C<br>2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | 12 | | EC 14-7-14 | |
| *110* | | 0.00 | | | | | | | |
| QC | **Memo** | | | | | | | | |
| Quality Control | 1) Inspect parts off machine<br>2) Complete FAI | | | | | | | | |

| Draw Nbr | Revision Nbr |
|---|---|
| D3139 | Rev C |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

DART AEROSPACE

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

**Item ID:** D3139-1 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Guard

**Start Date:** 1/07/14 **Start Qty:** 4.00 *4*
**Required Date:** 1/07/14 **Req'd Qty:** 4.00 *4*
**Reference:**

**Cust Item ID:**
**Customer:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | DAS 07 9-89 |
| *120* | | | | | | 12. | | | 14/07/21 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 125 | | 0.00 | | | | | | | DAS 07 9-89 |
| *125* | | | | | | 12. | | | 14/07/21 |
| HandThermo | **Memo** | 0.00 | | | | | | | |
| Hand Finishing Thermoforming | Drill & Countersink as per Dwg. | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

**Item ID:** D3139-1 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Guard

**Start Date:** 1/07/14 **Start Qty:** 4.00 *4* **Cust Item ID:**
**Required Date:** 1/07/14 **Req'd Qty:** 4.00 *4* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | | 0.00 | | | | | | | DAS 07 9-89 |
| *130* | Line Bender | | | | | 12 | | | |
| Thermoform | **Memo** | 0.00 | | | | | | | 14/07/21 |
| Thermoforming Machine | 1) Heat the part at .875" ( on the wide part near holes, centered to the element. heat till slightly soft & flip over once to heat opposite side<br>Using Bending tool DT 9694 bend the softenen plastic to 90 degrees and allow to cool for 1 minute<br><br>2) Place the bent angle down on the short side of the line bender and push to the edge. Heat the plastic at this location till slightly soft and flip to opposite side till soft. Insert bent end into bending jig DT 9694 in the opposite direction of the first bend, close the lid and bend the plastic upward to 90 degrees and let cool for 1 minute. | | | | | | | | |
| 140 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | DAS 07 9-89 |
| *140* | | | | | | 12 | | | |
| QC | **Memo** | 0.00 | | | | | | | 14/07/21 |
| Quality Control | Inspect and clean part if required | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

**Item ID:** D3139-1 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Guard

**Start Date:** 1/07/14 **Start Qty:** 4.00 *4* **Cust Item ID:**
**Required Date:** 1/07/14 **Req'd Qty:** 4.00 *4* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | 14/07/21 DAS 27 9-89 | | | 9 | 3 | | |
| *150* QC Quality Control | **Memo** | 0.00 | | | | | | | |
| 160 | Identify as per dwg & Stock Location: STOCK | 0.00 | | | | | | | |
| *160* Packaging Packaging | **Memo** | 0.00 | | | | DX | | 14-7-21 | DAS 28 9-89 |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* QC Quality Control | **Memo** | 0.00 | | | | MLJ | 14-07-22 | | |

PTO

14.7.21

DQA: [signature] Date: 14/12/13

QA Closed: [signature] Date: 14/8/27

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: B110721

Part No. D3139-1

NCR No. 14-4197

**DISPOSITION**

| | |
|---|---|
| Rework | ☐ |
| Scrap | ☒ |
| Use-as-is | ☐ |
| Suspected Unapproved | ☐ |

**AGAINST DEPARTMENT/PROCESS**

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| Skid-tube | ☐ | Crosstube | ☐ | Water Jet | ☐ | Engineering | ☐ |
| Machining | ☐ | Small Fab | ☐ | Prod. Eng. Coor. | ☐ | Quality | ☐ |
| Thermoforming | ☒ | Finishing | ☐ | Rec/Store/Packaging | ☐ | Other | ☐ |
| Large Fab | ☐ | Composite | ☐ | Supplier | ☐ | | ☐ |

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | 14/07/21 | 130 | 3 | To much moisture in the materiel | DAS 16 9-89 | Scrap + Destroy. | DL 14/07/21 | DAS 27 9-89 14/7/20 | DAS 16 9-89 Q12042 14/07/21 |
| Doc/Data | ☐ | | | | | | No Replace. | | | |
| Equip/Tooling | ☐ | | | | RC No Process in place to Dry "material" | Q2042 14/07/21 | ~~Start~~ create Procedure to Dry Mat. Before forming "STEP 122" | DL 14/09/10 | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☒ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

| | |
|---|---|
| ☐ | Bending |
| ☐ | Centre Not Concentric |
| ☐ | Cracks |
| ☐ | Crimp/Kink/Ripple/Wave |
| ☐ | Cuffs |
| ☐ | Crushing |
| ☐ | Heat Treat |
| ☐ | Inspection Strip in Tube |
| ☐ | Marks/Chatter |
| ☐ | Turning Sequence |
| ☐ | Wave/Twist in Tube |

**General**

| | |
|---|---|
| ☐ | Bend |
| ☐ | BOM/Route |
| ☐ | Broken/Damage/Defect |
| ☐ | Burrs |
| ☐ | Contamination |
| ☐ | Countersink |
| ☐ | Cut Too Short |
| ☐ | Drawing |
| ☐ | Drill Holes |
| ☐ | Finish |
| ☐ | Fit/Function |
| ☒ | Folio/Program |
| ☐ | Grain |
| ☐ | Hardware |
| ☐ | Inspection Incomplete/Unqualified |
| ☐ | Instructions Incomplete/Unclear |
| ☐ | Misaligned/off center |
| ☐ | Mislabeled |
| ☐ | Misread |
| ☐ | Off-set |
| ☐ | Out of Calibration |
| ☐ | Out of Sequence |
| ☐ | Outside Dimensions |
| ☐ | Over/Under tolerance |
| ☐ | Part Incorrect |
| ☐ | Part Lost/Missing |
| ☐ | Part Moved |
| ☐ | Positioned Wrong |
| ☐ | Power Loss/Surge |
| ☐ | Pressure/Forced |
| ☐ | Set-up |
| ☐ | Temperature/Cure |
| ☐ | Weld |
| ☐ | Wrong Stock Pulled |
| ☐ | Other |

# Picklist Print

*January-07-14 3:01:34 PM*



**Work Order ID:** 110721

**Parent Item:** D3139-1 **Start Date:** 1/07/14 **Required Date:** 1/07/14

**Parent Item Name:** Guard **Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev. A New Issue Form In-house 10/11/19 DL verf:DD IPP Rev. B Water jet Added 10/11/24 DL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **MLEXS.125-9034-01** 1/8" 9034 Lexan Sheet | | Purchased | No | | | 100 | sf | 73.0000 | **0.125** | **0.5263156** R 14-7-19 | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT019 | 73 | | |
| 125052 | 73 | | 3.6 |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
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**General**

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☐ Hardware
☐ Inspection Incomplete/Unqualified
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☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
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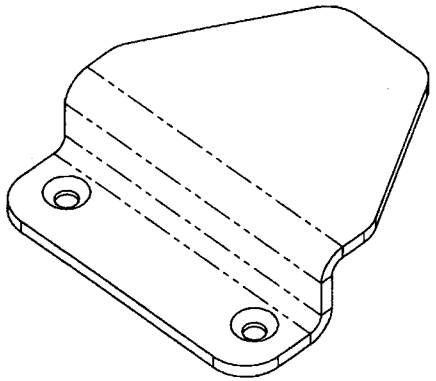
| DART AEROSPACE LTD | Work Order: | 110721 |
|---|---|---|
| | | |
| **Description:** Guard | Part Number: | D3139-1 |
| | | |
| **Inspection Dwg:** D3139 **Rev:** C | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

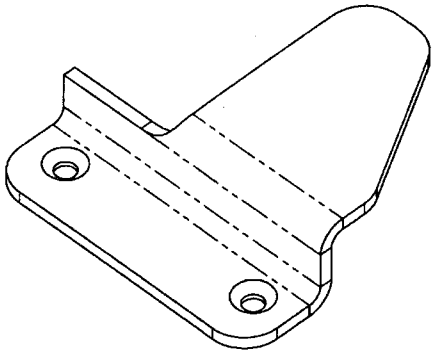
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø0.098 | +0.004/-0.001 | 0.099 | ✓✓ | | ✓ JKM65 | |
| 0.500 | +/-0.010 | 0.51 | ✓✓ | | | |
| 2.06 | +/-0.030 | 2.06 | ✓✓ | | | |
| 3.71 | +/-0.030 | 3.728 | ✓✓ | | | |
| 0.400 | +/-0.010 | 0.407 | ✓✓ | | | |
| 2.600 | +/-0.010 | 2.607 | ✓✓ | | | |
| 3.00 | +/-0.030 | 3.015 | ✓✓ | | | |
| 0.125 | +/-0.010 | 0.123 | ✓✓ | | | |
| | | | | | | |
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| | | | | | | |
| Ø 1.00" | | 1.004" | ✓ | | | |
| 0.25" | | 0.77" | ✓ | | | |
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| Measured by: | EL | Audited by: | DK. | Preliminary Approval: | |
|---|---|---|---|---|---|
| Date: | 14-7-19 | Date: | 14/07/21 | Date: | |

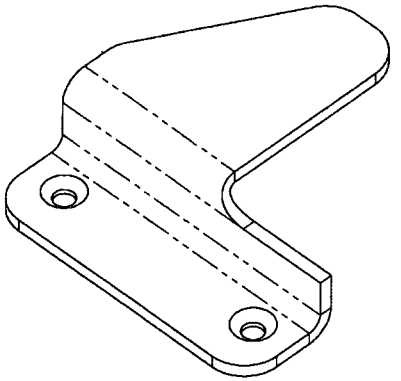
| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 13.03.04 | New Issue | KJ | M |



**D3139-1 GUARD**
(REPLACES PREMIER P/N B30-23000-237/-238)



**D3139-3 GUARD**
(REPLACES PREMIER P/N B30-23000-239)



**D3139-4 GUARD**
(REPLACES PREMIER P/N B30-23000-240)

RELEASED
2011-02-18

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| C | UPDATED TO CURRENT STD; CREATED D3139-1/-3 FLAT PATTERNS (SHT 3); 0.75 WAS 0.70 (B5-2, D1-2, D5-2). REF. CAR10-28. | MB | 11.01.07 |
| B | ADD PART MARKING | RF | 04.10.18 |
| A | NEW ISSUE | RF | 02.04.19 |

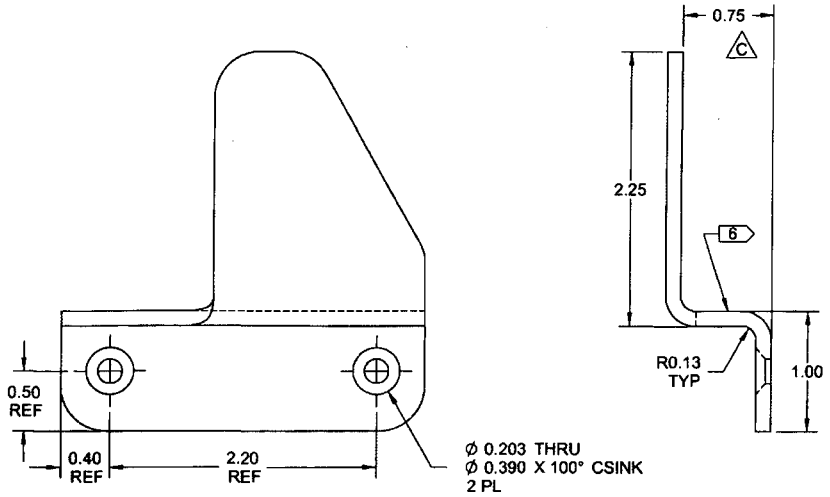
110121 MP
14/01/08

| | |
|---|---|
| DESIGN | |
| DRAWN | |
| CHECKED | |
| MFG. APPR. | |
| APPROVED | |
| DE APPR. | |
| DATE | 11.01.07 |

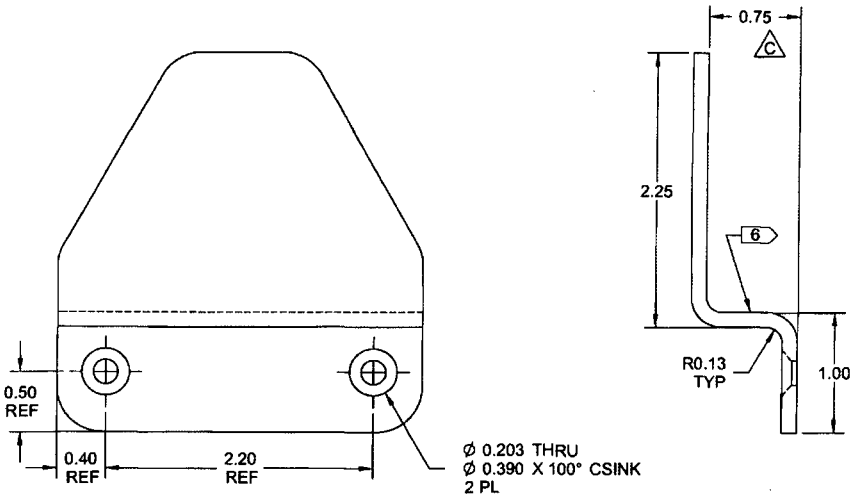
**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3139 REV. C
SHEET 1 OF 3
TITLE GUARD
SCALE NTS

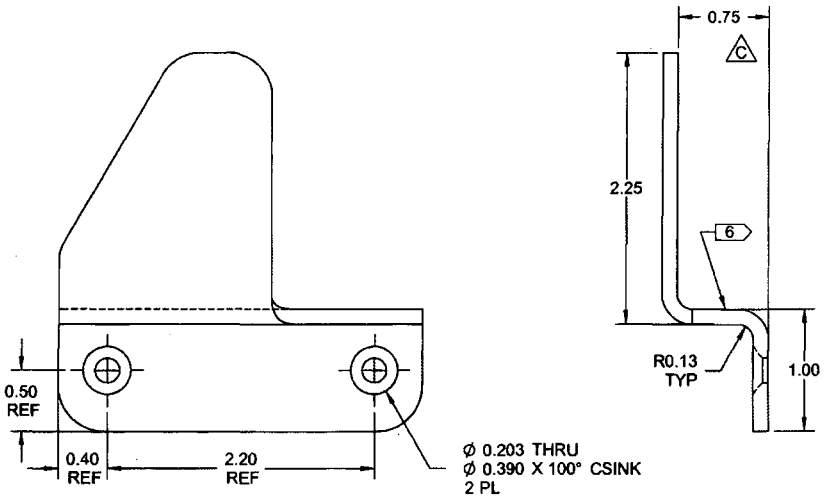
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**D3139-3 GUARD**
(MAKE FROM D3139-3F)




**D3139-1 GUARD**
(MAKE FROM D3139-1F)



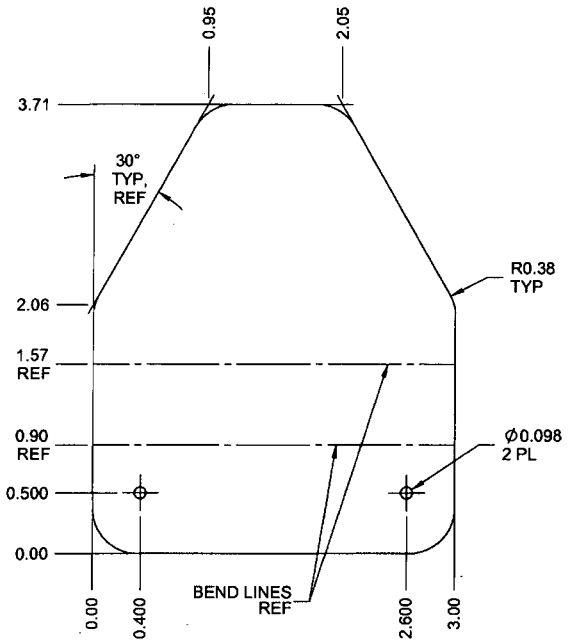

**D3139-4 GUARD**
(MAKE FROM D3139-3F)

RELEASED
2011-02-18

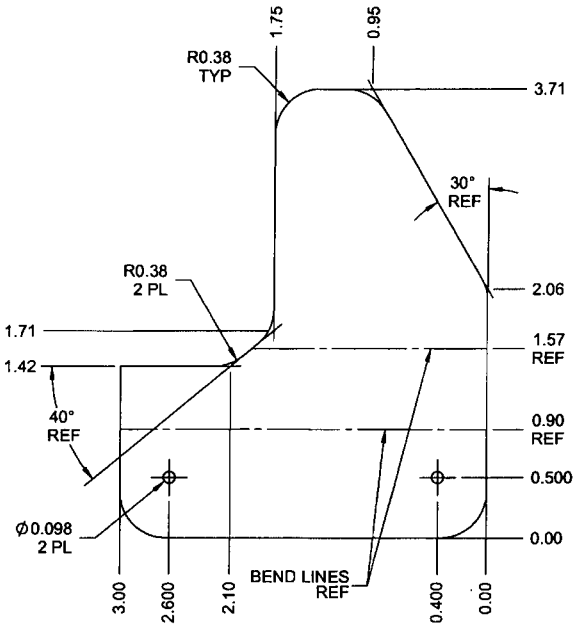
NOTES:
1) MATERIAL: PER D3139-1F/-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: WITH DART P/N "D3139-X" AND B/N "BXXXXX" PER QSI 044 6.1 (FINE POINT MARKER)
7) WEIGHT: 0.05 lbs

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D3139 REV. C |
| MFG. APPR. | | SHEET 2 OF 3 |
| APPROVED | | TITLE GUARD SCALE NTS |
| DE APPR. | | |
| DATE 11.01.07 | | |

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△C **D3139-1F GUARD FLAT PATTERN**




△C **D3139-3F GUARD FLAT PATTERN**

RELEASED
2011-02-18

NOTES:
1) MATERIAL: 9034 CLEAR LEXAN SHEET (SMOOTH TEXTURE), 0.125" THICK
REF. DART SPEC. MLEXS.125-9034-01
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 lbs

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D3139 REV. C SHEET 3 OF 3 |
| MFG. APPR. | | |
| APPROVED | | TITLE GUARD SCALE NTS |
| DE APPR. | | |
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